

Date: Thursday, 5/25/2006 3:37:35 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LATCH PLATE		
Job Number	: 27252		Part Number	: D2621		
Estimate Number	: 10511		Drawing Number	: D2621 REV. B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 5/25/2006	S.O. No. : N/A	Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 6/20/2006		
Previous Run	: 25903		Qty:	40	Um:	Each
Written By	: <u>SEE 10 COMMENT BELOW</u>		Comment			
Checked & Approved By	: <u>JK 06.05.25</u>		Comment			
Comment	: Est: C 02.02.28 Added inspection level 8 and level 5 SM					

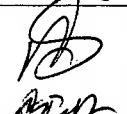
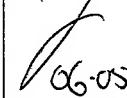
Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	-M5052H32S040	5052-H32 .040 Sheet
<p>Comment: Qty.: 0.0656 sf(s)/Unit Total : 2.6250 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S040) Batch: <u>M17835</u> <u>MM 06.05.30</u></p>		
2.0	SHEAR	SHEAR <p>Comment: SHEAR Cut blank: 4.000" x 2.130" <u>N/A</u> <u>MM 06.05.29</u></p>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<p>Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio and Dwg D2621 <u>WATER JET</u> 2- Deburr <u>Day Rev B</u> <u>MM 06.05.31</u> Identify as D2621 <u>Phy Rev B</u> <u>MM 06.05.30</u> (40)</p>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>MM 06.05.30</u> (40)</p>		
5.0	QC8	SECOND CHECK
<p>Comment: SECOND CHECK <u>EN 06/05/31 40</u></p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/05/03	83	one (1) Part scrap. MATERIAL Detonated when cutting out INSIDE pattern on water jet.	 	Scrap and destroy Part.	Er 06/05/03	 	 	 

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: 

Date: 06/06/03

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 5/25/2006 3:37:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH PLATE

Job Number: 27252

Part Number: D2621

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DC 06/06/01 (40)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

DC 06/06/01 (40)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AL 06/06/01 (40)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STS3

AL 06/06/01 (40)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AL 06/06/02 (40)

Job Completion



W 06/06/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27252
Description: Latch Plate	Part Number:	D2621
Inspection Dwg: D2621	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

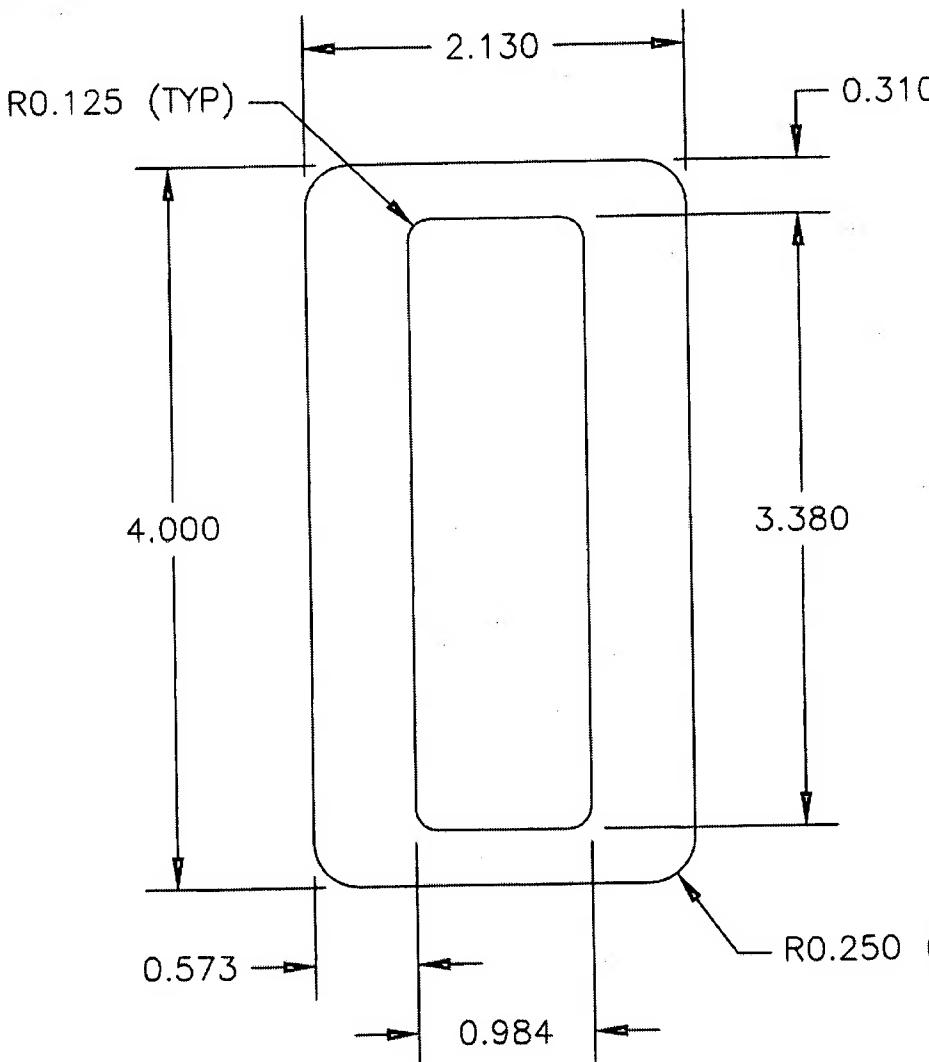
Measured by:	<u>MT</u>	Audited by:	<u>EP</u>	Prototype Approval:	N/A
Date:	06/05/30	Date:	06/05/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	<i>[Signature]</i>



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ff</i>	APPROVED <i>ff</i>	DRAWING NO. D2621	REV. B SHEET 1 OF 1
DATE 00.06.01		TITLE LATCH PLATE	SCALE 1:1
A	96.08.15	NEW ISSUE	
B	00.06.01	ADDED FINISH; R0.125 WAS R0.118	

RELEASER
00.06.05 - ff



MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) OR 2024-T3 (QQ-A-250/4) 0.040 THICK
 FINISH: CHEMICAL CONVERSION COAT PER DART 005 4.1
 POWDER COAT BLACK SANTEX (REF. 4.3.5.7) PER DART QSI 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO 27252

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.